

31p June 30

Dart Aerospace Ltd.

Date: Friday, 6/16/2006 7:36:48 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 27533	
Estimate Number : 10759	
P.O. Number : NIA	Part Number : D34623
This Issue : 6/16/2006 S.O. No. : NIA	Drawing Number : D3462 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : 6/12/2006 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 25534	Material : NIA
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 6/19/2006
Checked & Approved By : <u>[Signature]</u>	Qty: 4 Um: Each
Comment : EST REV. A 05.11.18 NEW ISSUE EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0375X03000	M304 SS 3/8"X3"
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Comment: Qty.: 0.2660 f(s)/Unit Total : 1.0640 f(s)
304 BAR .500 X 2.500

Batch#: M19207 SAO 06:06:20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

SAO 06:06:20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 06:06:20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

206-06-21 (4)
(010)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CARL

Rec'd 6/22 (4)

6.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

SAO 06/06/23

Job Completion



U 06-06-23

Slip June 30

Dart Aerospace Ltd.

Date: Monday, 6/12/2006 3:49:12 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 27533	
Estimate Number : 10759	
P.O. Number :	Part Number : D34623
This Issue : 6/12/2006 S.O. No. :	Drawing Number : D3462 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 25534	Material :
Written By : <u> </u>	Due Date : 6/19/2006 Qty: 4 Um: Each
Checked & Approved By : <u> </u>	
Comment : EST REV. AC 05.11.18 NEW ISSUE EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304B0500X2500 0375X0300 (Qty: 266) BATCH: M19207	304 BAR 3/8" x 3" BAR.
Comment: Qty: 0.2500 f(s)/Unit Total: 1.0000 f(s) 304 BAR 500 X 2.500 SAD 06:06:20 (4)		

2.0	BAND SAW W/X	BAND SAW
Comment: BAND SAW Cut blank " long		

3.0	HAAS1 WATER Jet	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA 603 and Dwg D3462 2-Deburr SAD 06:06:20 (4)		

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 06:06:20 (4)		

5.0	QC8	SECOND CHECK
Comment: SECOND CHECK 06-06-21 (4)		

6.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:49:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27533

Part Number: D34623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DS 06/26/23 (4)

Job Completion



D:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

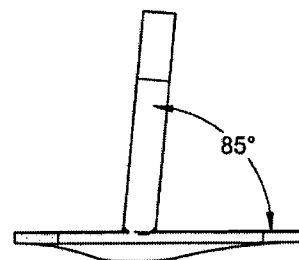
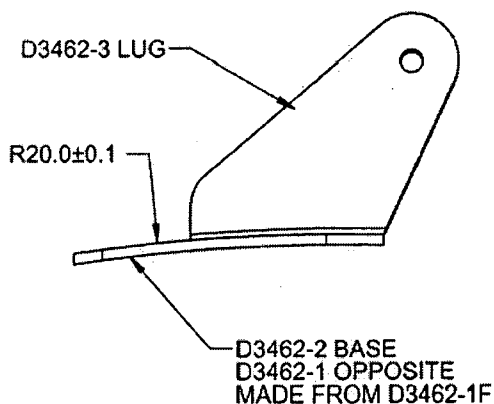
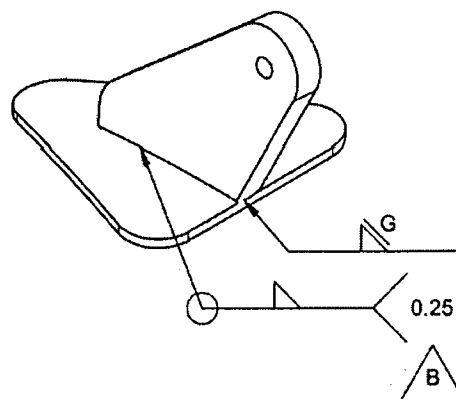
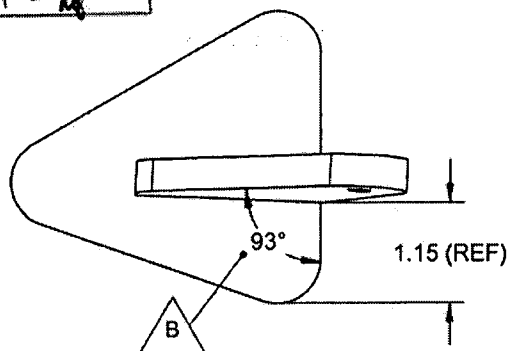
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3462	REV. B SHEET 1 OF 2
DATE 05.12.05		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIMENSIONS	

RELEASED05.12.09 *[Signature]*

D3462-042 BRACKET ASSEMBLY (SHOWN)
D3462-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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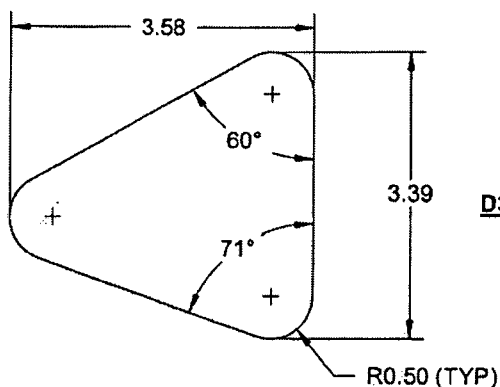
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CHECKED #	APPROVED #	DRAWING NO. D3462	REV. B SHEET 2 OF 2
DATE 05.12.05		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED

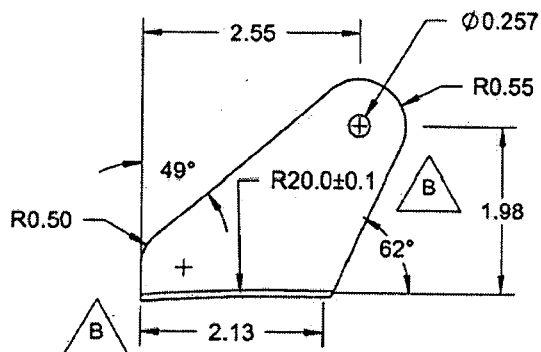
05.12.09 #



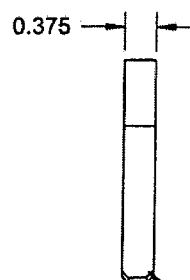
D3462-1F FLAT PATTERN

D3462-1F BASE

- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK (REF. DART SPEC. M304S11 GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010



D3462-3 LUG



0.08 x 45°
CHAMFER
(TYP)

D3462-3

- 1) MATERIAL: AISI 304 SS BAR (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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